

Date: Thursday, 29/06/2006 9:10:25 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 3.540" OUTER TUBE, NO RIDGE (BO 105)					
Job Number	: 27774	Part Number	: D2962150					
Estimate Number	: 12465	Drawing Number	: D2962 REV A					
P.O. Number	: N/A	Project Number	: N/A					
This Issue	: 29/06/2006	Type	S.O. No. : N/A					
Prsh Rev.	: NC	Drawing Revision	: A					
First Issue	: N/A	Material	: N/A					
Previous Run	: N/A	Due Date	: 06/07/2006					
Written By	<u>See Component Below</u>							
Checked & Approved By	<u>N</u>							
Comment	: Est Rev:A New Issue 06-06-20 JLM							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>1702</u> a) Extrude as per Dwg D2962 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 125" long g) Bon L Canada Inc. tool # DAA-897127 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	
2.0	D2962150P	3.540 Outer Tube, Extrut	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 13.0000 Each(s) 3.540 Outer Tube, Extrut	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	

Date: Thursday, 29/06/2006 9:10:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3.540" OUTER TUBE, NO RIDGE (BO 105)

Job Number: 27774

Part Number: D2962150

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0

QC6

DIMENSIONAL CHECK



06-07-07 13

Comment: DIMENSIONAL CHECK

Inspect dimensions per Dwg D2962

Check Pull test per Dwg D2962 for compliance page attached.

Check hardness with Webster tester

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

6 06-07-07

13

6.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-07-07

Job Completion



500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

06/14/06	141204	22011	
Customer No. 00001200	File No. 00307505	Date 22371010	Date 6/14/06

Shipped To DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	Shipped To DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7																																										
<table border="1"> <thead> <tr> <th>Item No.</th> <th>Part No.</th> <th>Item Description</th> <th>Customer Part</th> </tr> </thead> <tbody> <tr> <td>1.000</td> <td>DAA-3-2</td> <td>150" MILL 6061 T6</td> <td>D2962150</td> </tr> <tr> <td>Gross Weight</td> <td>103 KGS</td> <td></td> <td></td> </tr> <tr> <td>Net Wt.</td> <td>93 KG</td> <td>13 PC</td> <td>50 M</td> </tr> <tr> <td colspan="2">Specification</td> <td colspan="2">Data Desc.</td> </tr> <tr> <td colspan="2">AMS-QQ-A-200/8 & ASTM B221-00</td> <td colspan="2"></td> </tr> </tbody> </table>		Item No.	Part No.	Item Description	Customer Part	1.000	DAA-3-2	150" MILL 6061 T6	D2962150	Gross Weight	103 KGS			Net Wt.	93 KG	13 PC	50 M	Specification		Data Desc.		AMS-QQ-A-200/8 & ASTM B221-00																					
Item No.	Part No.	Item Description	Customer Part																																								
1.000	DAA-3-2	150" MILL 6061 T6	D2962150																																								
Gross Weight	103 KGS																																										
Net Wt.	93 KG	13 PC	50 M																																								
Specification		Data Desc.																																									
AMS-QQ-A-200/8 & ASTM B221-00																																											
<p>Mechanical Tests:</p> <table> <thead> <tr> <th>Test No.</th> <th>Tensile MPA / KSI</th> <th>Yield MPA / KSI</th> <th>%Elongation</th> <th>Conductivity</th> <th>Bend/Drift</th> <th>HREW</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>323.5 / 46.9</td> <td>298.0 / 43.2</td> <td>10.0</td> <td>.0</td> <td>.92</td> <td></td> </tr> </tbody> </table> <p>Chemical Analysis:</p> <table> <thead> <tr> <th>SI</th> <th>FE</th> <th>CU</th> <th>MN</th> <th>MG</th> <th>CR</th> <th>NI</th> <th>ZN</th> <th>GA</th> <th>V</th> <th>TI</th> <th>ZR</th> <th>OTHER</th> </tr> </thead> <tbody> <tr> <td>.68</td> <td>.25</td> <td>.25</td> <td>.07</td> <td>.90</td> <td>.06</td> <td>.000</td> <td>.07</td> <td>.000</td> <td>.009</td> <td>.01</td> <td>.000</td> <td>.00</td> </tr> </tbody> </table>				Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW	1	323.5 / 46.9	298.0 / 43.2	10.0	.0	.92		SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER	.68	.25	.25	.07	.90	.06	.000	.07	.000	.009	.01	.000	.00
Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW																																					
1	323.5 / 46.9	298.0 / 43.2	10.0	.0	.92																																						
SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER																															
.68	.25	.25	.07	.90	.06	.000	.07	.000	.009	.01	.000	.00																															
<p>This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.</p>																																											
<p>Ritchie Bisnauth, QA Manager Signed for Bon L Canada</p> <p>P.D. 1205</p> 																																											

CERT

Date: Tuesday, 5/9/2006 9:13:25 AM
 User: Linda Lacelle

Process Sheet

Customer	:	CC-DAR01	Drawing Name	:	SKIDTUBE EC135 PROTOTYPE
Job Number	:	022A	Part Number	:	INITIAL PROTOTYPE
Estimate Number	:	10068	Drawing Number	:	P601-637
P.O. Number	:		Project Number	:	P601-637
This Issue	:	5/9/2006	Drawing Revision	:	
Prsh Rev.	:	NC	Material	:	
First Issue	:	/ /	Due Date	:	2/1/2006
Previous Run	:	020A	Qty:	1	Um: Each
Written By					
Checked & Approved By					
Comment	Project #: _____ Description: _____				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MFG ENGINEERING	MFG ENGINEERING

Comment: MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

ISSUE P/0 1200
 TO BOW L

REFERENCE ONLY

2.0	D2962150	3.540 Outer Tube, Extrut	
Comment: Qty.: 10.0000 (s)/Unit Total : 10.0000 (s) 3.540 Outer Tube, Extrut			

Tuesday, 5/9/2006 9:13:25 AM

Linda Lacelle

Process Sheet

Customer: CC-DAR01

Drawing Name: SKIDTUBE EC135 PROTOTYPE

Job Number: 022A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #: Machine Or Operation:

Description :

3.0 D2963125 105 I Beam Extrusion



Comment: Qty.: 10.0000 (s)/Unit Total : 10.0000 (s)
105 I Beam Extrusion

PLC 6/15 (14)

Job Completion



QC5/6 Inspect Job.06.28 B/14

REFERENCE ONLY